

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266194-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266194-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266194-1	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266194-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266194-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266194-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266194-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



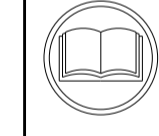
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.30 mm [.051]	F
INSUL	2.40 mm [.094]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: YAZAKI TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RH TYPE TERMINAL FEMALE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.50 mm [.157-.177 IN]	Ø -		
TERMINAL APPLICATION SPECIFICATION	72-WT10-2733		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	
2113417-1	7116-4488-08	1949745-1	7158-3167-80	1.35-1.70
2113417-2	7116-4416-08			
2113417-3	7116-4416-02			
2113417-4	7B16-4416-02			
1949838-1	7114-4416-02			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.05+/-0.05 [1.041+/-0.002]	7.3
22 AWG	0.96+/-0.05 [0.038+/-0.002]	8.1



1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
7. THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN THE TERMINAL MANUFACTURER'S SPECIFICATIONS. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN THE MANUFACTURER'S APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION AND OBTAIN APPROVAL FROM TERMINAL MANUFACTURER FOR THIS CUSTOM REQUIREMENT.
8. TERMINAL LUBRICANT RECOMMENDED.

***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APPV
A	66	C		ECR-19-002523	15FEB2019	TB	CT
		C1		ECR-19004175	15MAR2019	MZ	TE
		D		ECR-19-0011204	16JUL2019	LG	TE
		E		ECR-19-011339	19JUL2019	FZ	TE

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
3	-	-	-	1	1	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	-	1	1	-	1-1752354-9	STANDOFF, HOLD-DOWN	180
-	-	-	-	1	1	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	-	1	1	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	-	1	1	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	-	1	1	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
8	-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
5	-	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
1	-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	1	4-1633928-0	ANVIL, COMBINATION	8
1	-	1	1	1	1	1	5-240641-4	SPACER	7
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119781-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1	6-1633965-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	1	2	2	1	1	1	3-1673600-9	CRIMPER, WIRE	1

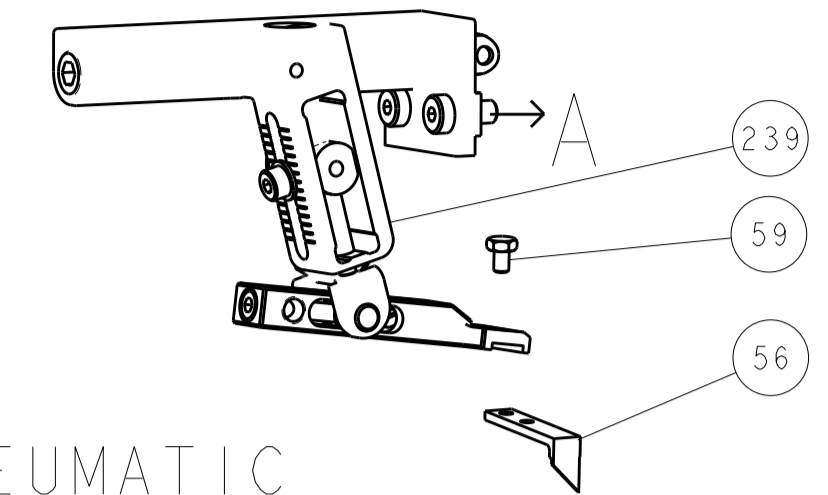
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	
MATERIAL:				FINISH:		WEIGHT:	

OWN	J. HUANG	17JAN2014	TE Connectivity Harrisburg, PA 17105-3608
CHK	L. ZHANG	17JAN2014	
APVD	J. GUO	17JAN2014	
PRODUCT SPEC			Ocean Side Feed Applicator
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266194	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV E

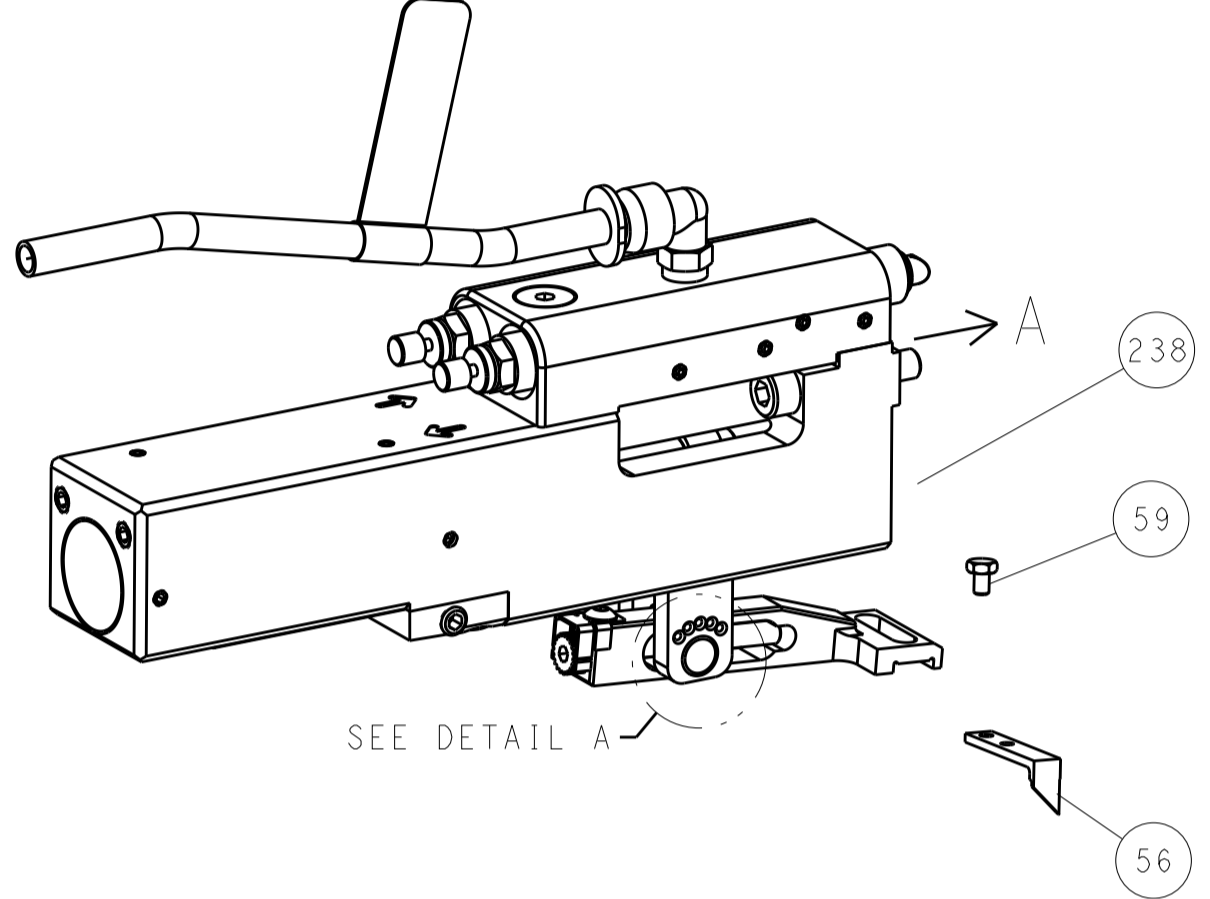
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

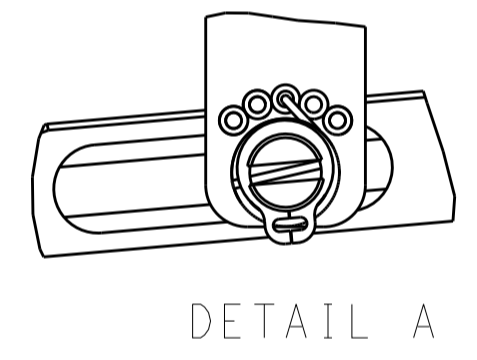
FEED TYPE MECHANICAL



PNEUMATIC

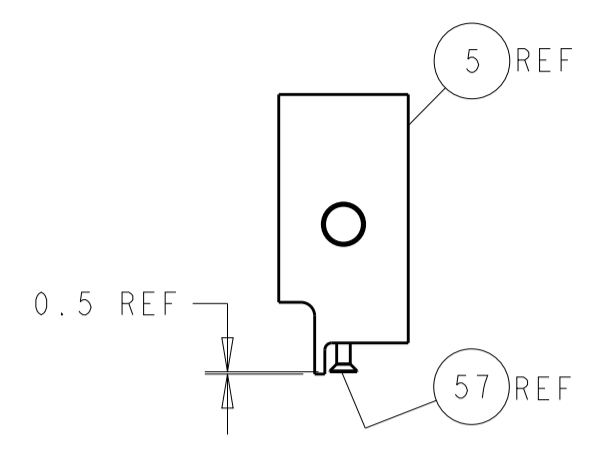
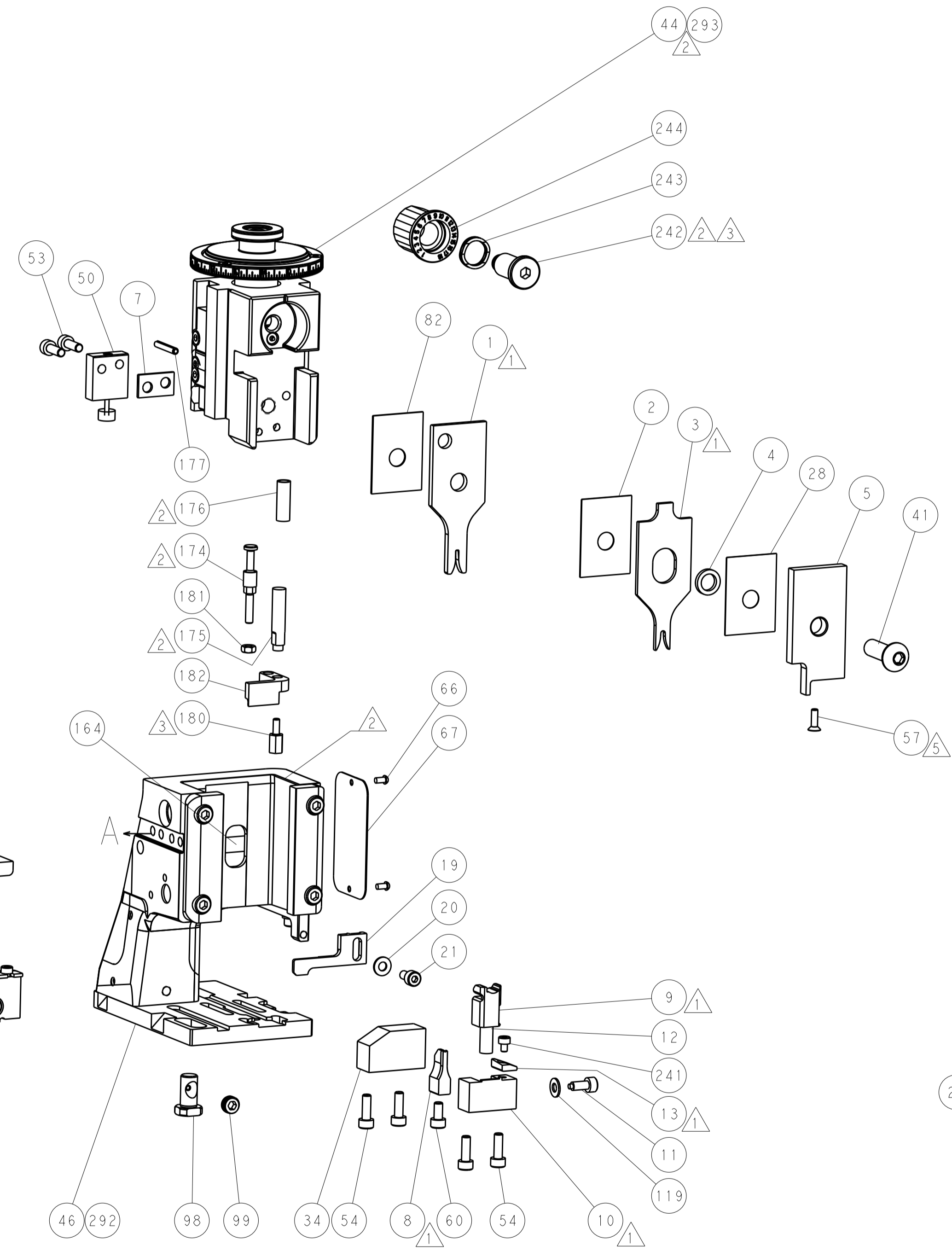
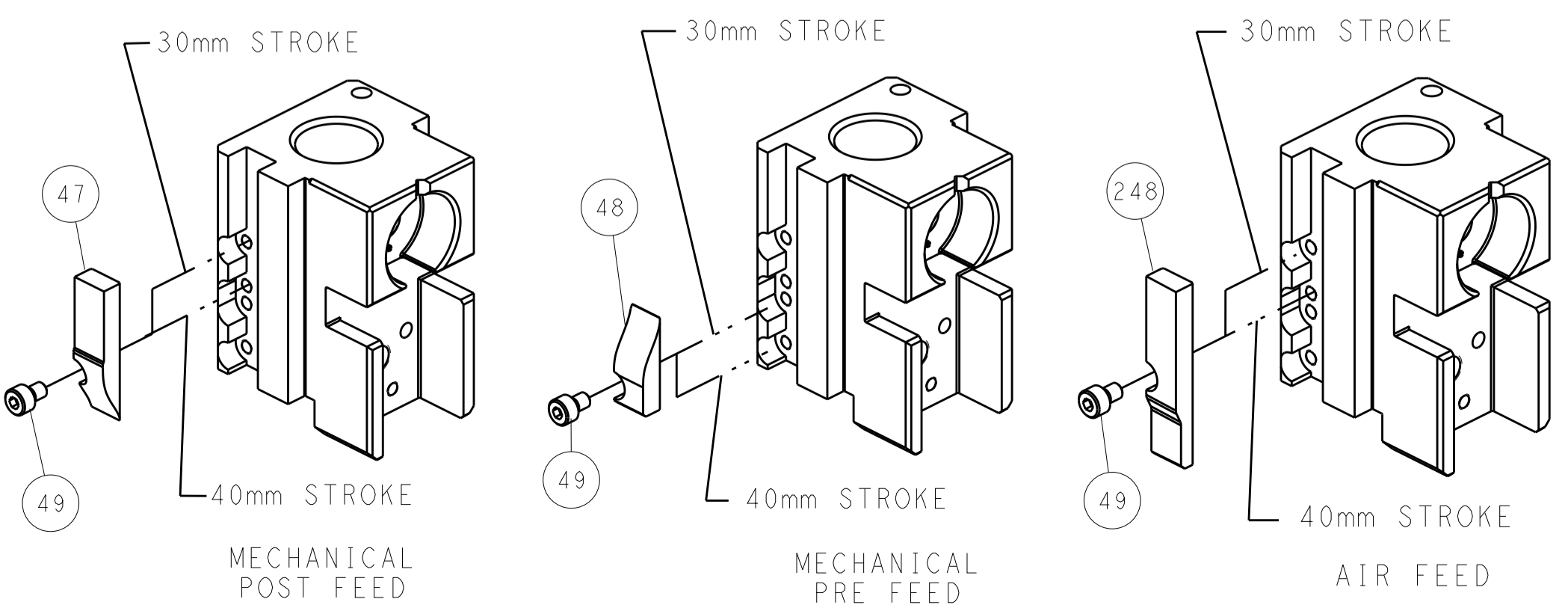


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

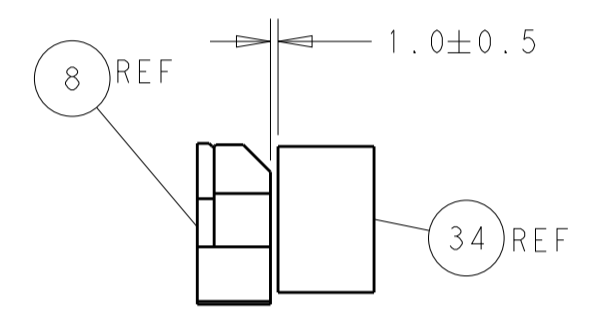


DETAIL A

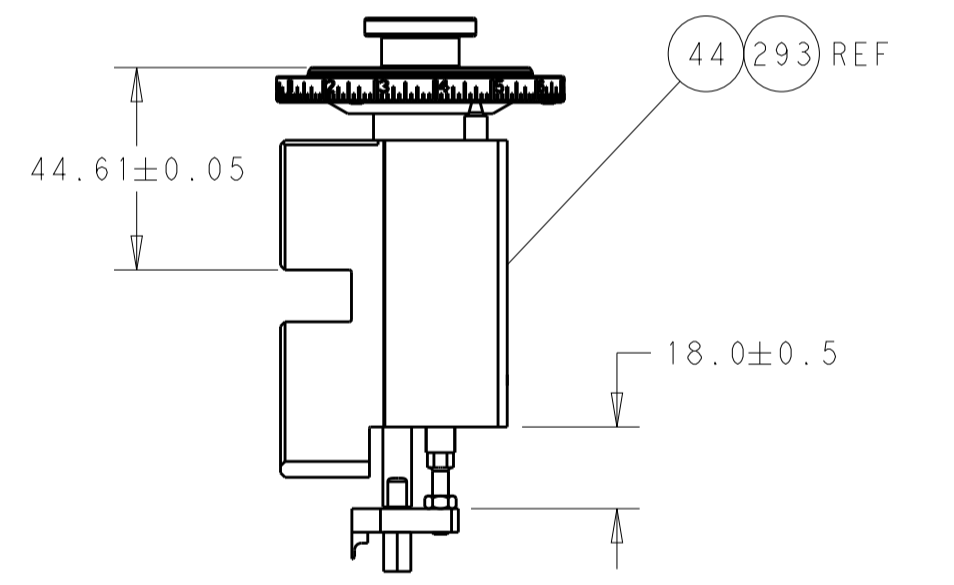
CAM POSITIONS



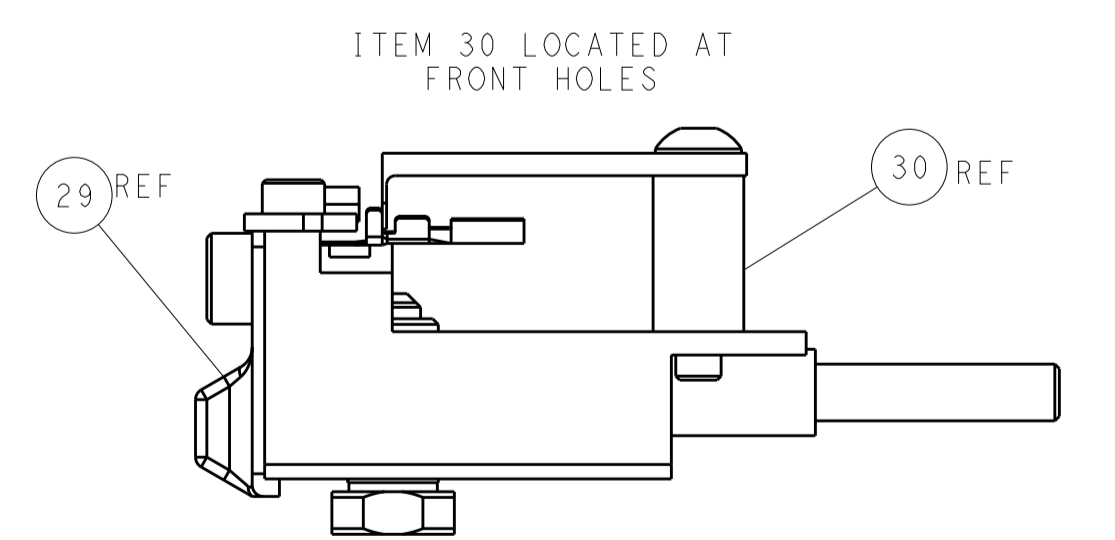
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN R. HUANG 17JAN2014 CHK L. ZHANG 17JAN2014 APVD H. GUO 17JAN2014		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266194	
WEIGHT:		SCALE: 1:2		SHEET: 2 of 4		REV: E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266194-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266194-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266194-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.30 mm [.051]	F
INSUL	2.40 mm [.094]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: YAZAKI TERMINAL TE CRIMP SPECIFICATION	
TERMINAL NAME: RH TYPE TERMINAL FEMALE	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.00-4.50 mm [1.57-.177 IN]	∅ -
TERMINAL APPLICATION SPECIFICATION	72-WT10-2733

TERMINALS APPLIED				
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	SEAL INSULATION DIAMETER RANGE
2113417-1	7116-4488-08	1949745-1	7158-3167-80	1.35-1.70
2113417-2	7116-4416-08			
2113417-3	7116-4416-02			
2113417-4	7B16-4416-02			
1949838-1	7114-4416-02			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm ²	1.05 +/- 0.05 [1.041 +/- .002]	7.3
22 AWG	0.96 +/- 0.05 [0.038 +/- .002]	8.1

***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- △ CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- △ APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN THE TERMINAL MANUFACTURER'S SPECIFICATIONS. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN THE MANUFACTURER'S APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION AND OBTAIN APPROVAL FROM TERMINAL MANUFACTURER FOR THIS CUSTOM REQUIREMENT.
- △ TERMINAL LUBRICANT RECOMMENDED.

LOC	DIST	REV	DATE	BY	APPV
A	66	-	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
-	1	1		2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△	-	1		2119083-1	RETAINER, INSULATION DIAL	242
-	1	1		7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1		2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-		2844940-1	AIR FEED MODULE	238
-	REF	REF		994970-2	COUNTER, MAGNETIC	164
-	1	-		2119641-2	FEED CAM, AIR FEED	151
-	1	1		2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4		2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1		2119653-2	FEED CAM, POST FEED	142
-	1	1		1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1		1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1		1-18028-2	WASHER, FLAT, REG M4	119
△	-	1		2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1		2844908-1	SCREW, LOCKING	99
-	1	1		2844907-1	POST, LOCKING	98
-	1	1		455888-6	SPACER, CRIMPER	82
-	1	1		1803607-3	DOCUMENTATION PACKAGE	71
-	1	1		2119740-1	TAG, IDENTIFICATION	67
-	2	2		2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1		5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
△	-	1		985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1		1338685-1	PAWL, FEED	56
-	2	2		2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1		1803382-1	HOLD DOWN, SPRING LOADED	50
-	1	2		18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1		2119652-1	FEED CAM, PRE FEED	48
-	1	1		1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1		1752356-3	SUPPORT, TERMINAL	34
-	2	2		2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1		455888-3	SPACER, CRIMPER	28
-	1	1		1320928-2	STRIP GUIDE	24
-	1	1		2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1		1-18028-2	WASHER, FLAT, REG M4	20
-	1	1		2119533-1	STRIPPER, SIDE FEED	19
-	1	1		2119806-1	INSERT, SHEAR	13
△	-	1		3-22280-3	SPRING, COMPRESSION	12
-	1	1		1-356885-4	STOP, SHEAR	11
-	1	1		2119805-1	SHEAR HOLDER, FRONT	10
△	-	1		318707-1	FLOATING SHEAR, FRONT	9
△	1	1		4-1633928-0	ANVIL, COMBINATION	8
△	-	1		5-240641-4	SPACER	7
-	-	-		-	-	7
-	-	-		-	-	6
-	1	1		2119781-2	DEPRESSOR, SHEAR	5
-	1	1		2-238011-2	BLOCK, CRIMPER SPACER	4
△	1	1		6-1633965-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1		455888-4	SPACER, CRIMPER	2
△	1	1		3-1673600-9	CRIMPER, WIRE	1

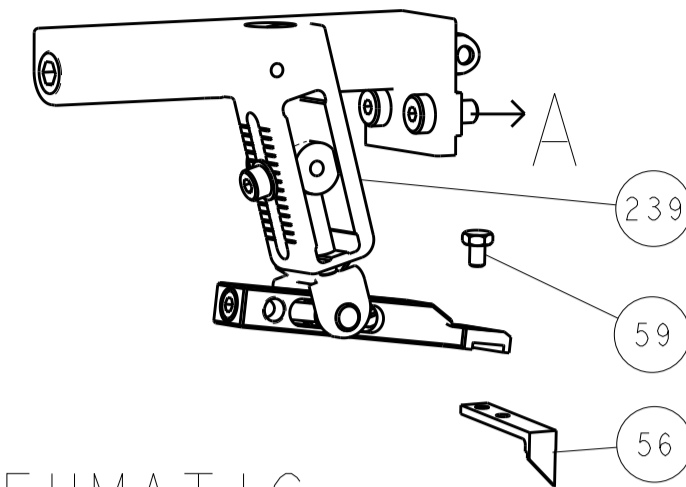
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

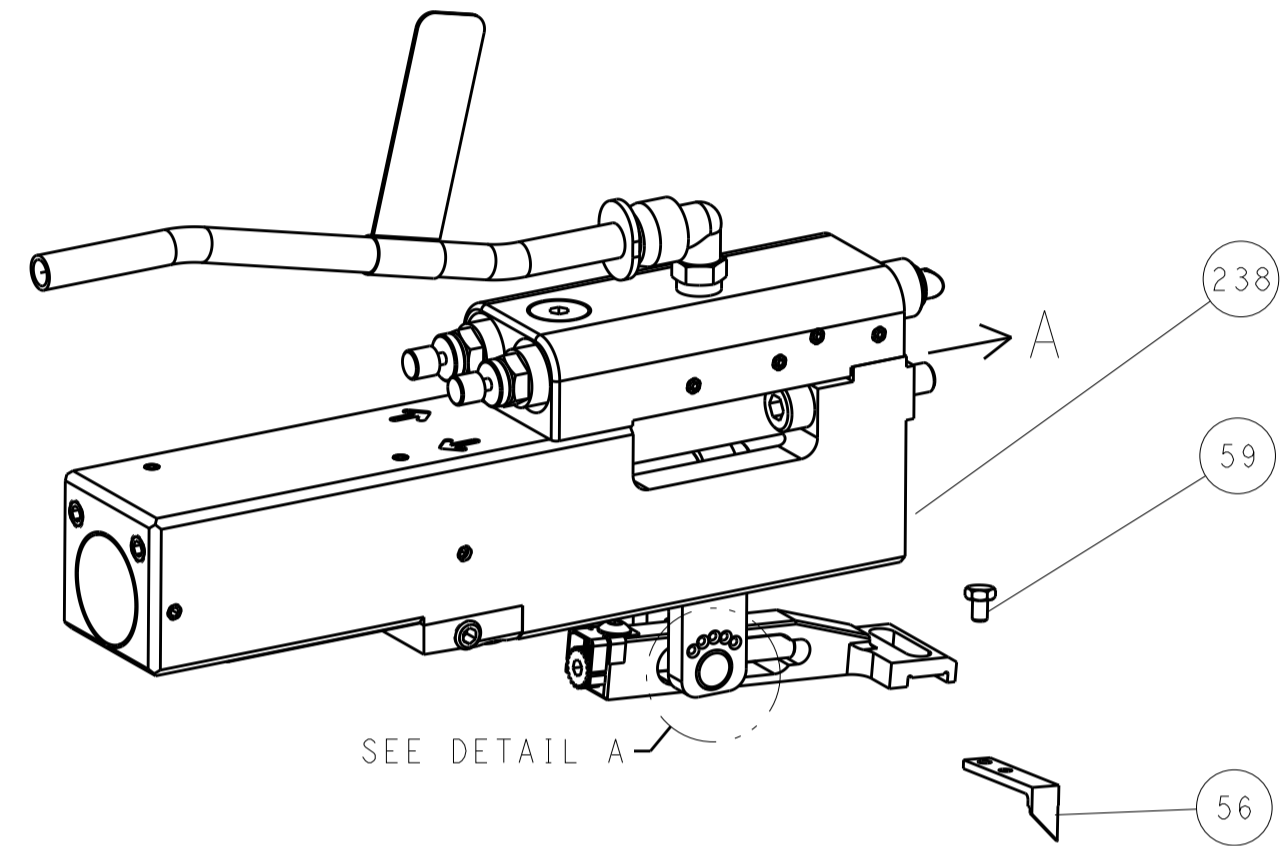
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DATE	17JAN2014	CHK	H. GUO	DATE	17JAN2014	CHK	H. GUO
PRODUCT SPEC	-						
APPLICATION SPEC	-						
WEIGHT	-						
SCALE	1:2						
SHEET	3 OF 4						
REV	E						

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

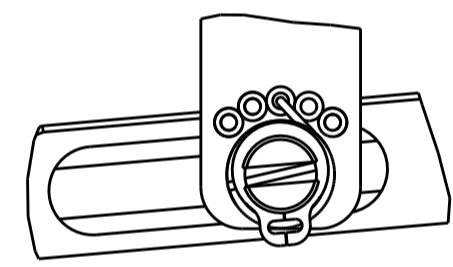
FEED TYPE MECHANICAL



PNEUMATIC

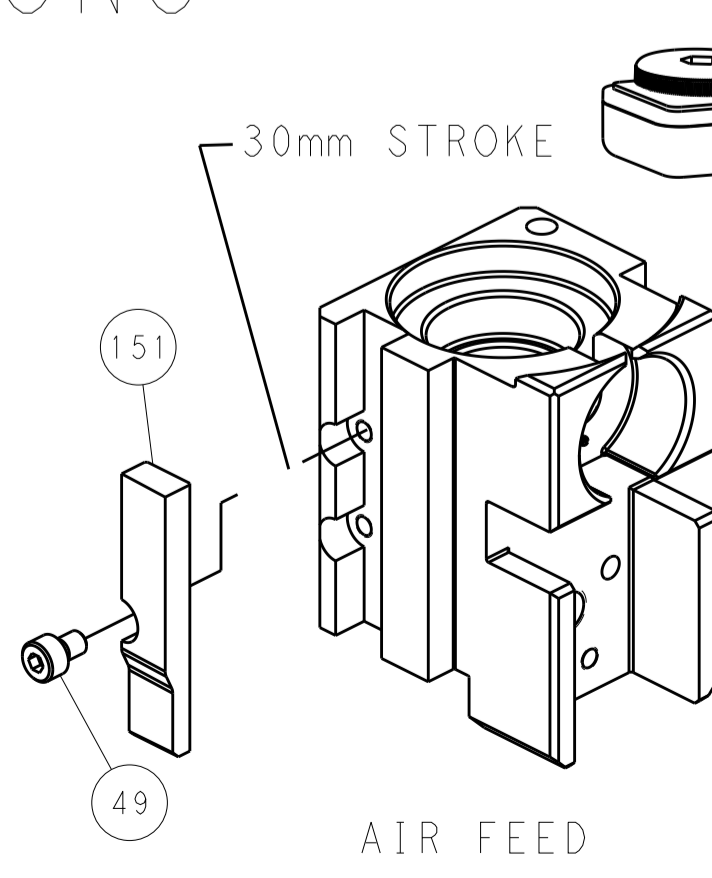
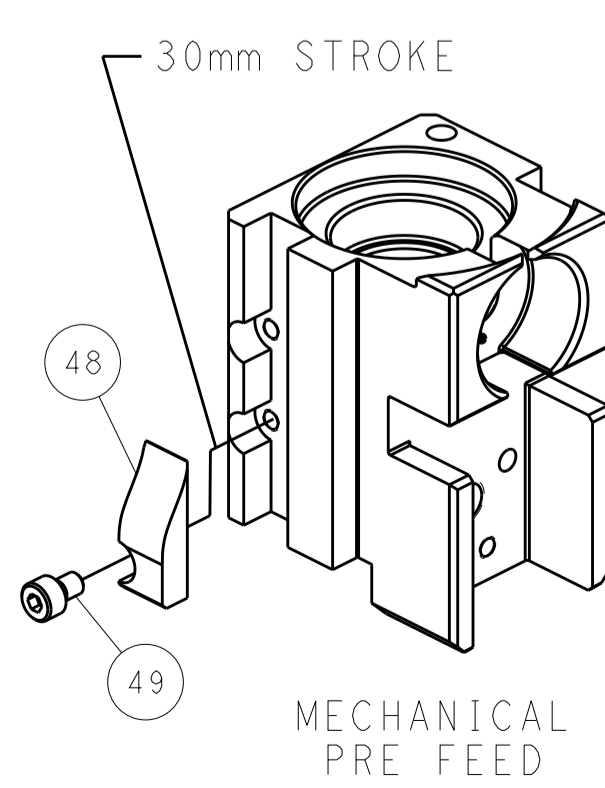
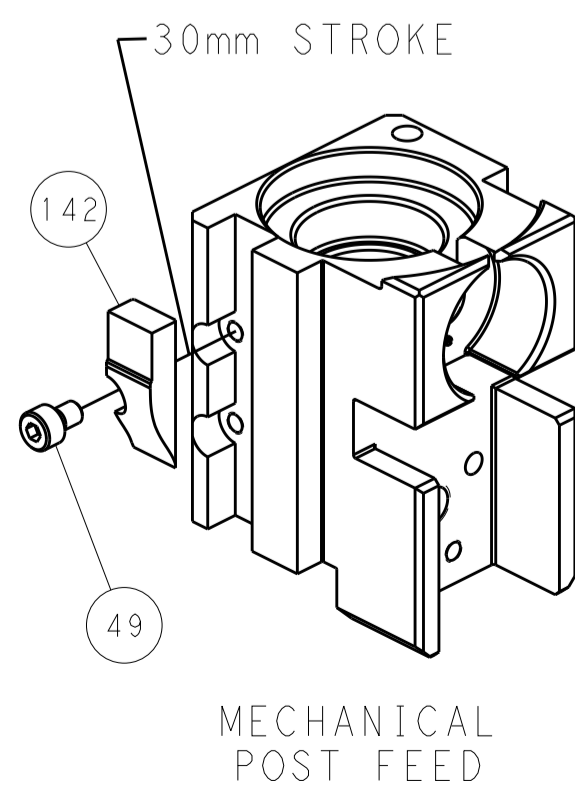


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

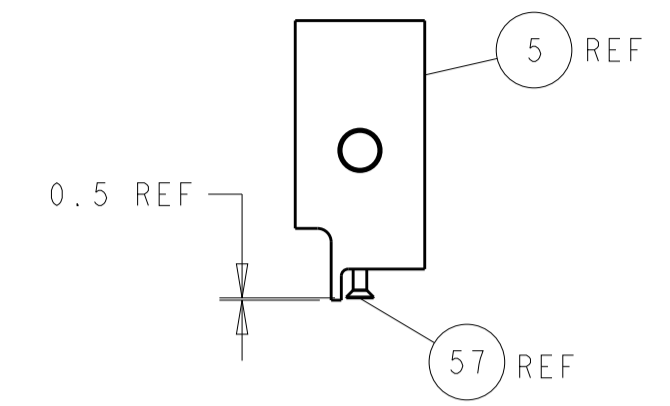
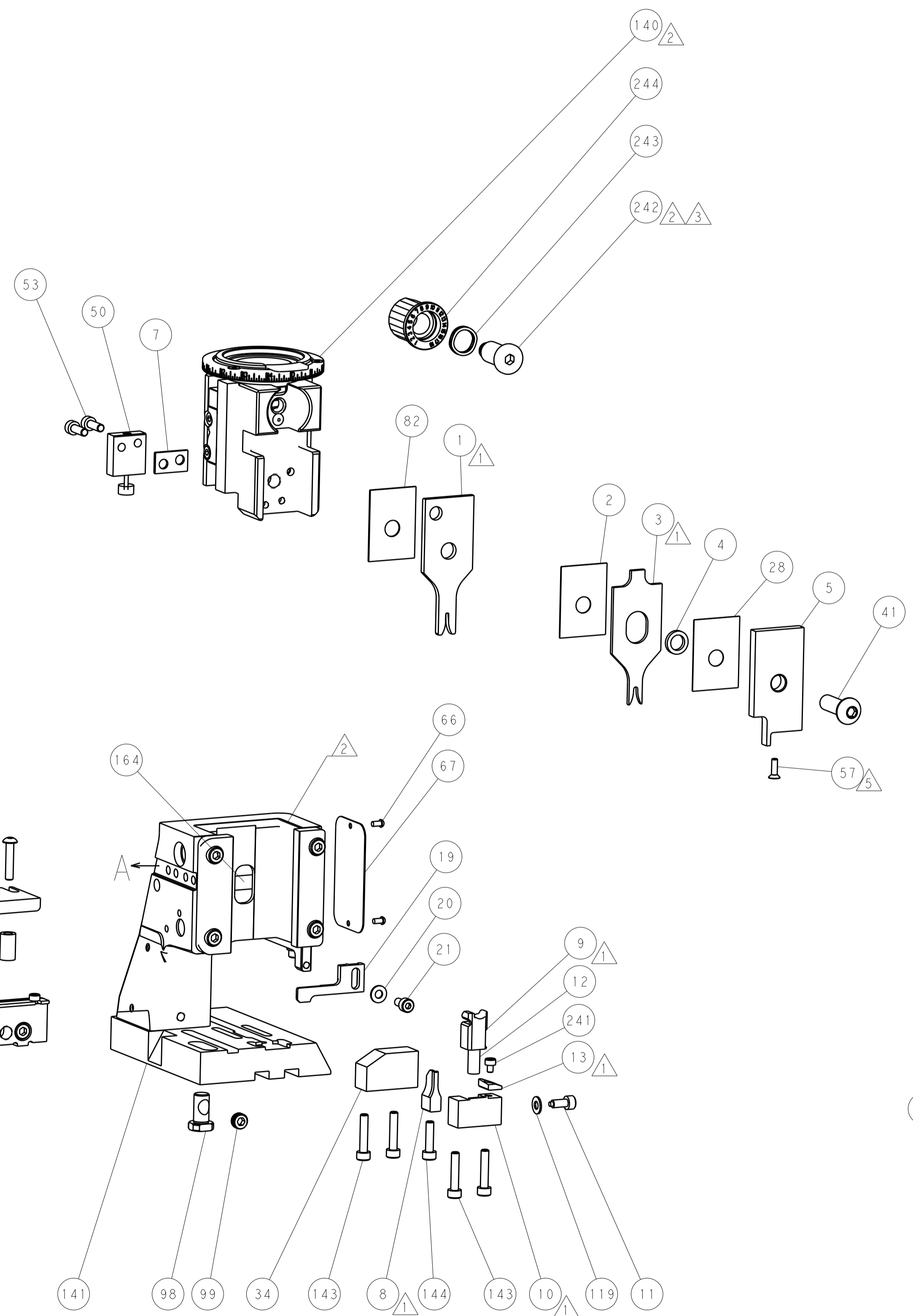


DETAIL A

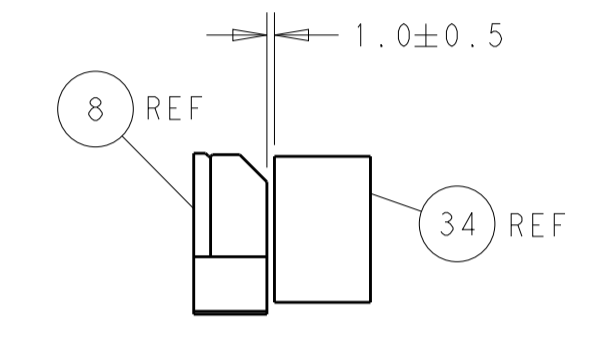
CAM POSITIONS



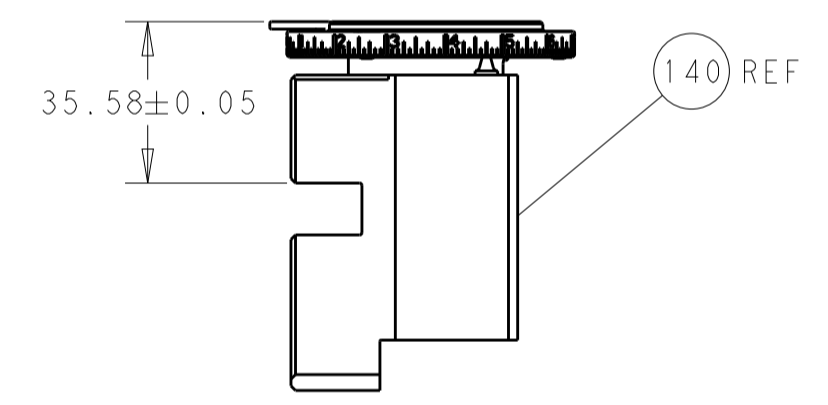
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



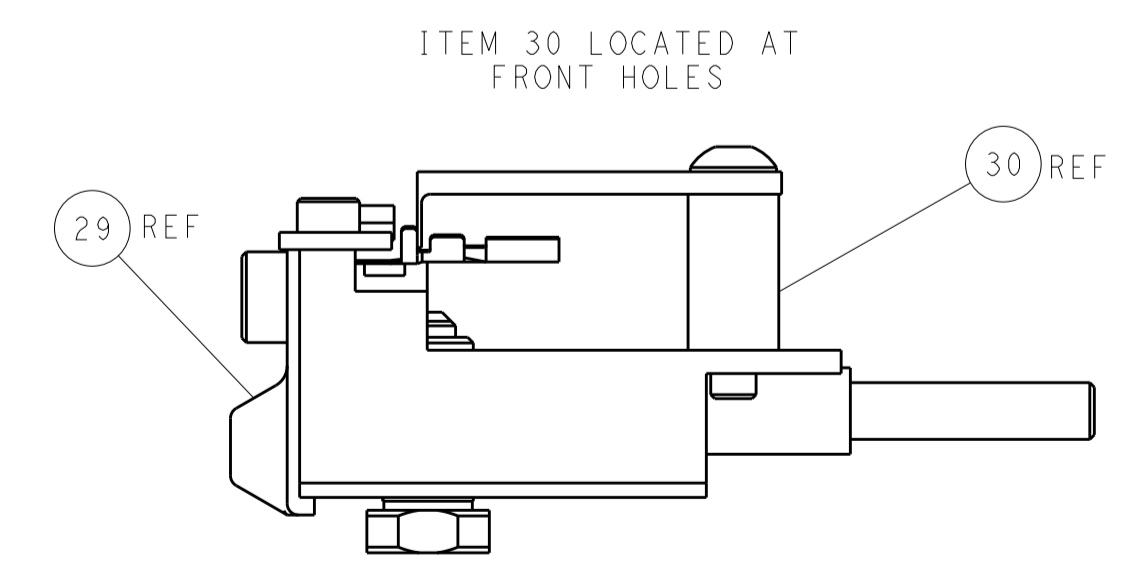
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN H. HUANG 17JAN2014 CHK L. ZHANG 17JAN2014 APVD H. GUO 17JAN2014		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME: Ocean Side Feed Applicator	
WEIGHT:		SCALE: 1:2		SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266194		RESTRICTED TO:	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEET 4 OF 4		REV E		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	

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